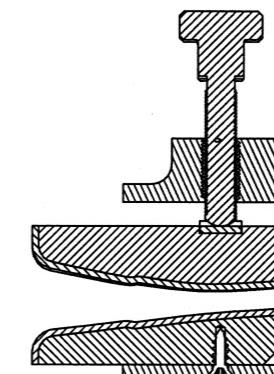
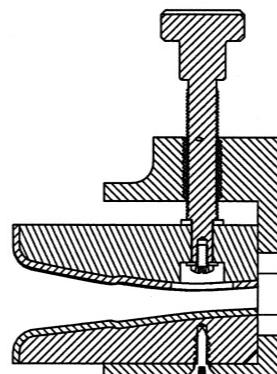
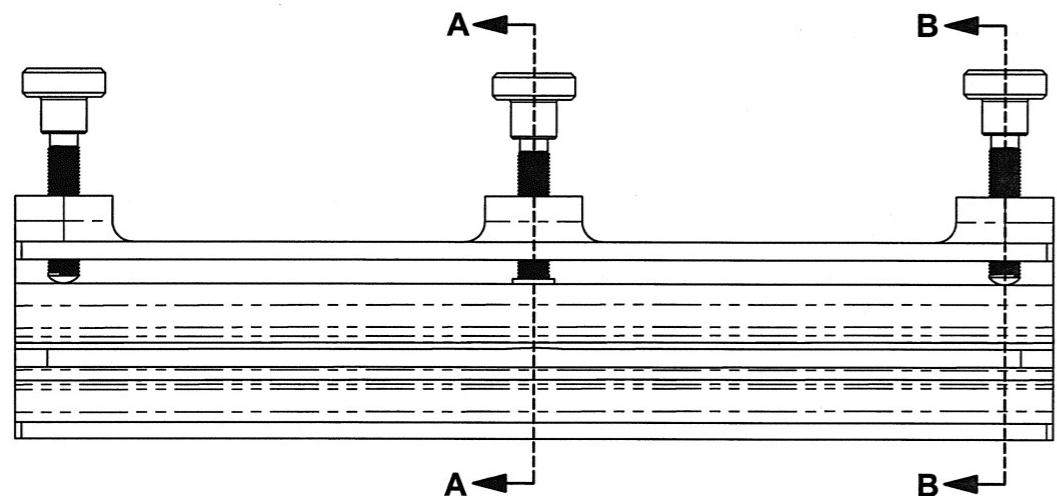
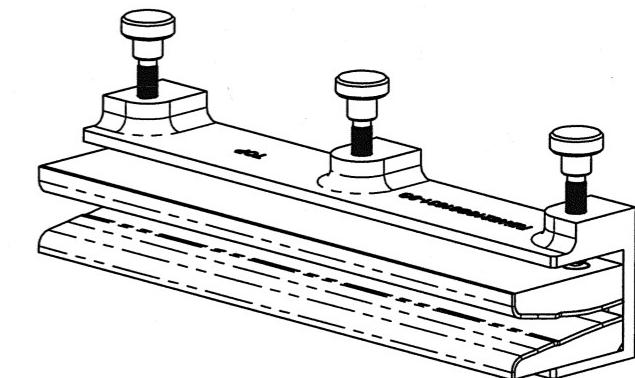


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6210G01631-8G-1	PUSH SCREW
-2	2	RBW6210G01631-8G-2	LOCKING SCREW
-3	1	RBW6210G01631-8G-3	SUPPORT ASSY
-5	1	RBW6210G01631-8G-5	UPPER PLATE ASSY
-9	1	RBW6210G01631-8G-9	LOWER PLATE ASSY
12	3	McMaster#90294A804 OR EQUIV.	316 SS PHILLIPS FLAT HEAD WOOD SCREW #10 X 5/8" LG.
13	1	McMaster#91400A170 OR EQUIV.	18-8 SS PHILLIPS ROUNDED HEAD SCREW #6-40 X 1/4" LG.
14	1	McMaster#98017A615 OR EQUIV.	18-8 SS WASHER 0.149" ID. X 0.375" OD. X 0.032" THK.
15	1	NAS1149-C0463R	WASHER



SECTION A-A

SECTION B-B

### RBW6210G01631-8G M/R BLADE LOCKING PROTECTION TOOL

12

NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A

3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) IDENTIFICATION: N/A  
7) ASSEMBLE AS SHOWN  
8) APPLY NICKEL ANTI-SEIZE LOCTITE LB 771 ON THREADS OF ITEMS -1 AND -2 THEN ASSEMBLE WITH ITEM -3, AND REMOVE EXCESS  
9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 12 THEN ASSEMBLE WITH ITEM -9, AND REMOVE EXCESS  
10) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 13 THEN ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS  
11) INSTALL ITEMS 12 AND 13 HAND TIGHT  
12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

C	UPDATED DRAWING TEMPLATE ITEM 12 WAS McMaster#91771A829 OR EQUIV. IS McMaster#90294A804 OR EQUIV. -1, -2 DIM WAS 0.16 REF IS 0.16. DIM WAS Ø0.34 REF IS Ø0.34. -4 DIM WAS R0.20 IS R0.25. DIM WAS R0.21 IS R0.25 -9 REMOVED ITEM 17 McMaster#91732A231 OR EQUIV. -10 DIM WAS TAP FOR #10-32 HELICAL INSERT Ø 0.35 IS Ø0.109 Ø 0.45	19-794	KPT	
B	-6 PART TITLE WAS RBW6210G01631-8G-5 UPPER PLATE IS RBW6210G01631-8G-6 UPPER PLATE. HOLE DIM WAS Ø0.5550/0.5545 2 PL IS Ø0.516 2 PL -8 DIM WAS Ø0.5555/0.5550 IS Ø0.50 -9 ITEM 17 PART# WAS McMaster#91723A231 OR EQUIV. IS McMaster#91732A231 OR EQUIV.	19-521	KPT	
A	NEW ISSUE	18-655	KPT	
REV.	DESCRIPTION	ECN #	BY	
DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	KPT			
CHECKED	KPT	REV. C		
MFG. APPR.	DP	TOOL PART #		
APPROVED	X	RBW6210G01631-8G		
DATE 2019-07-03			SHEET 1 OF 13	
			TITLE M/R BLADE LOCKING PROTECTION TOOL	
			SCALE	NTS
			COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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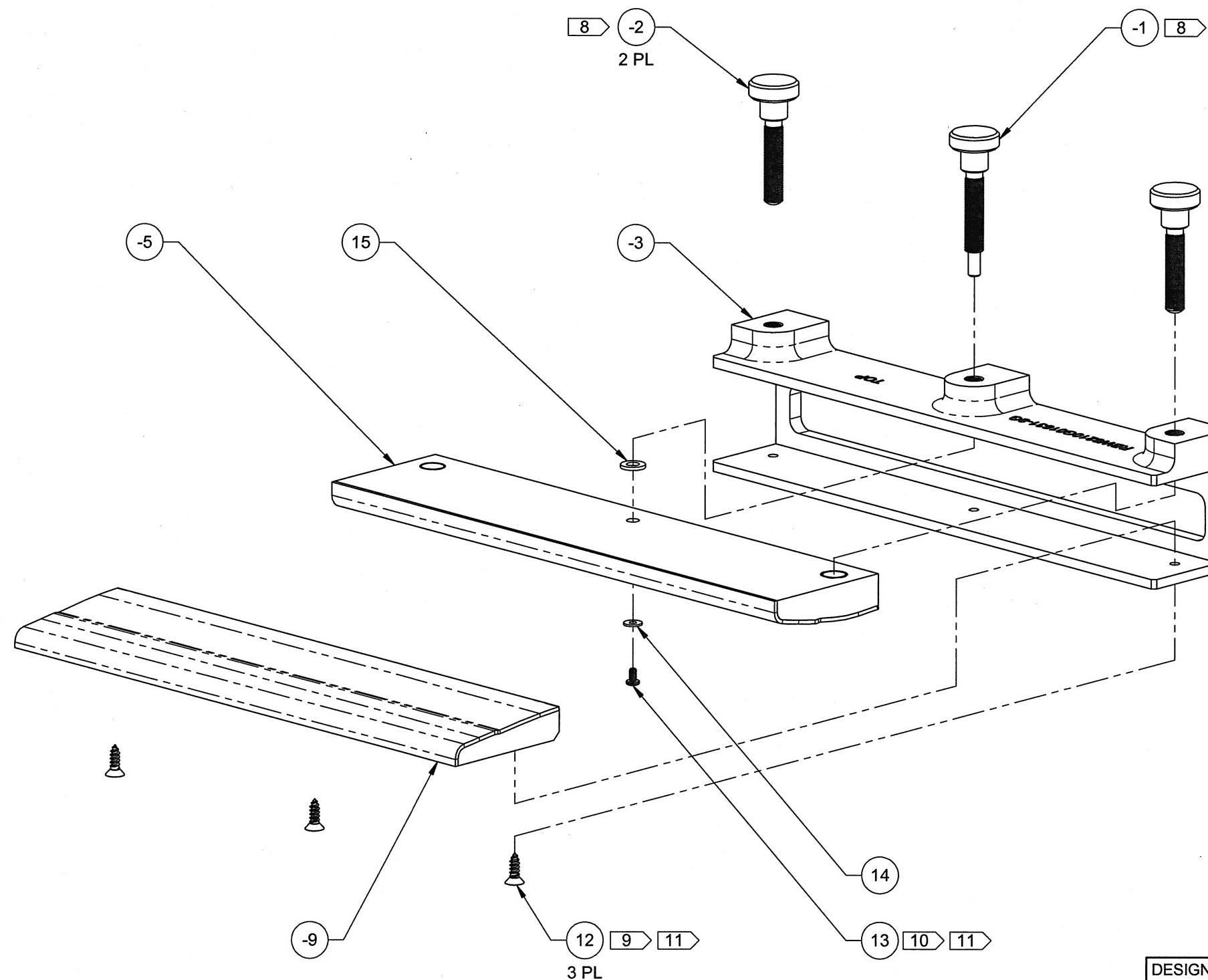
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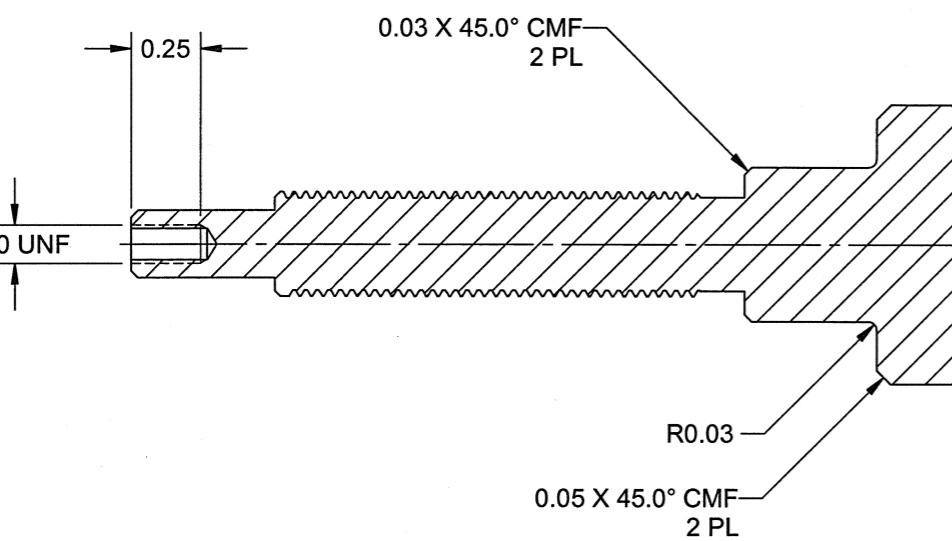
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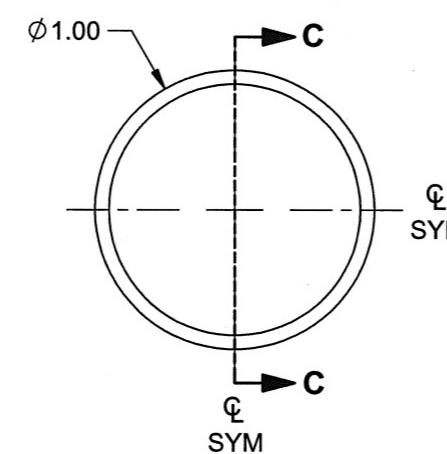
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DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	DP	RBW6210G01631-8G	
APPROVED	WJ	REV. C	
DATE	2019-07-03	SHEET 2 OF 13	
TITLE		SCALE	1:1
M/R BLADE LOCKING PROTECTION TOOL NTS		MM	INCH
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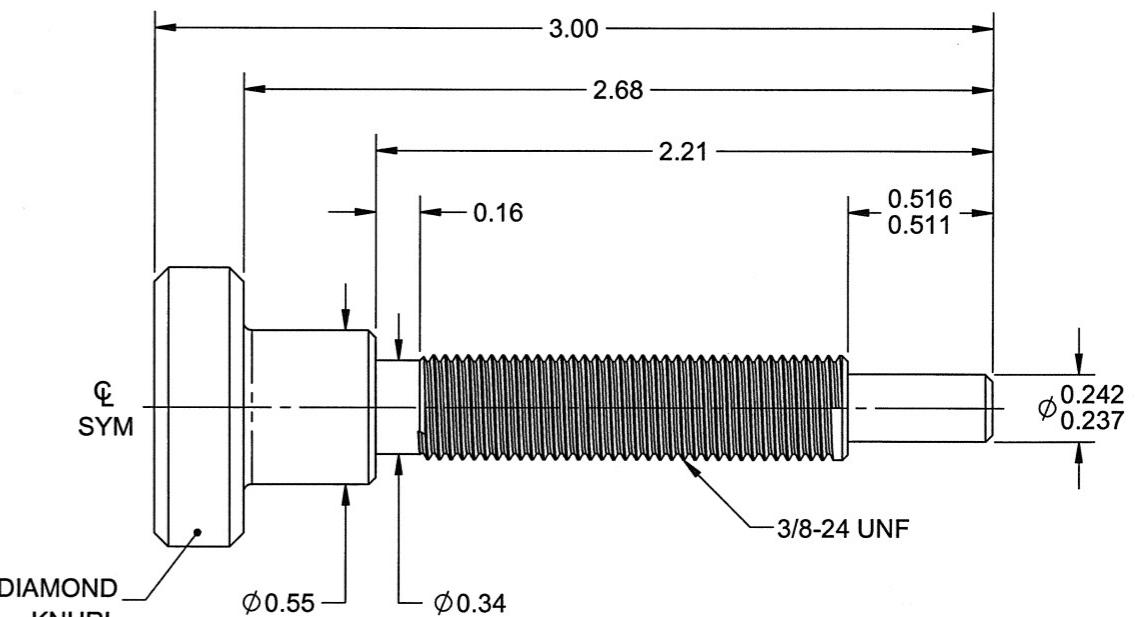
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SECTION C-C



RBW6210G01631-8G-1 PUSH SCREW



NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	DP	REV. C	
APPROVED		RBW6210G01631-8G	
DATE 2019-07-03		SHEET 3 OF 13	
TITLE		SCALE	NTS
M/R BLADE LOCKING PROTECTION TOOL			
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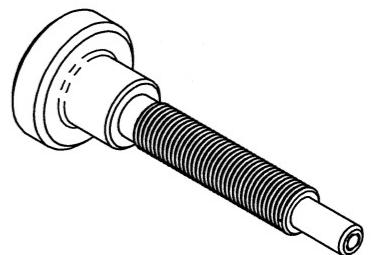
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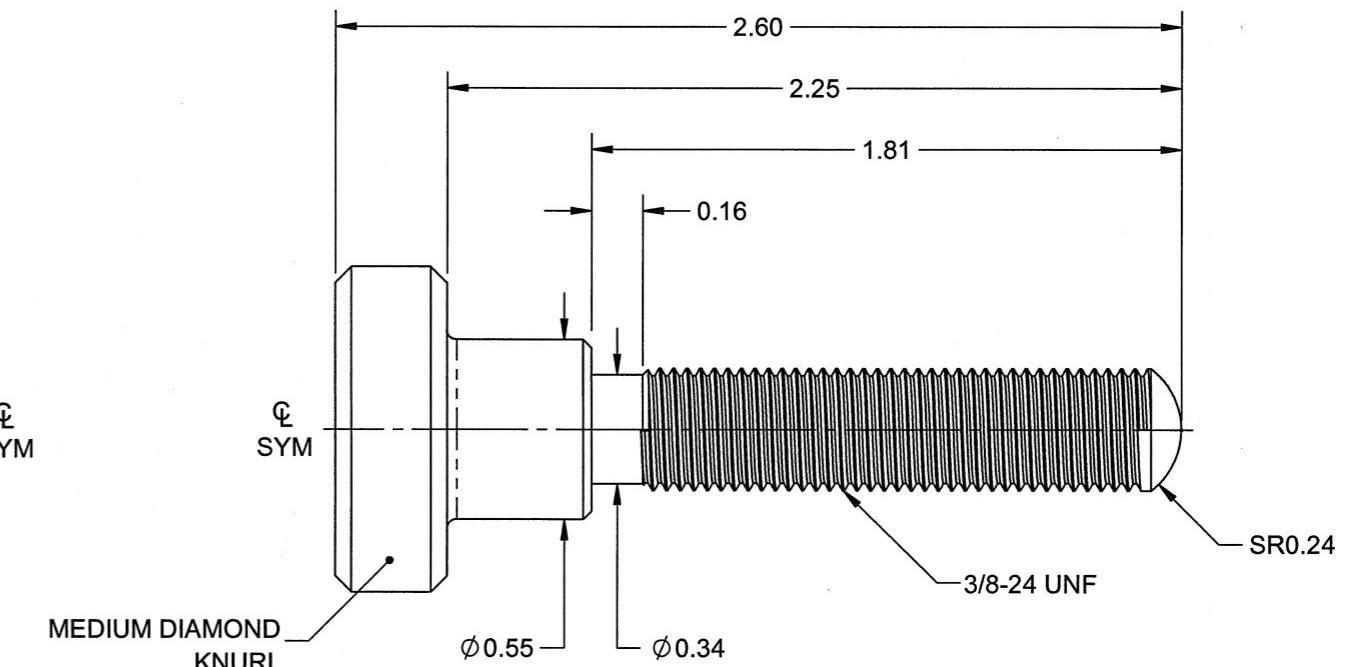
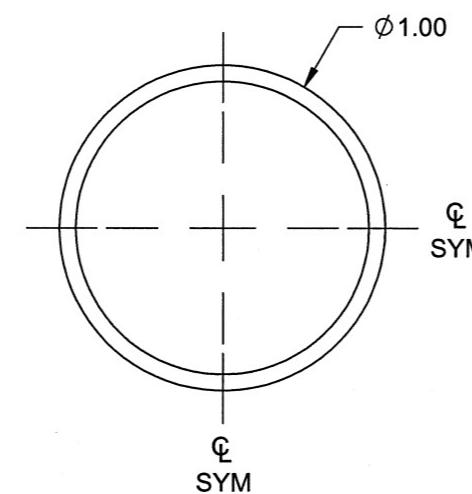
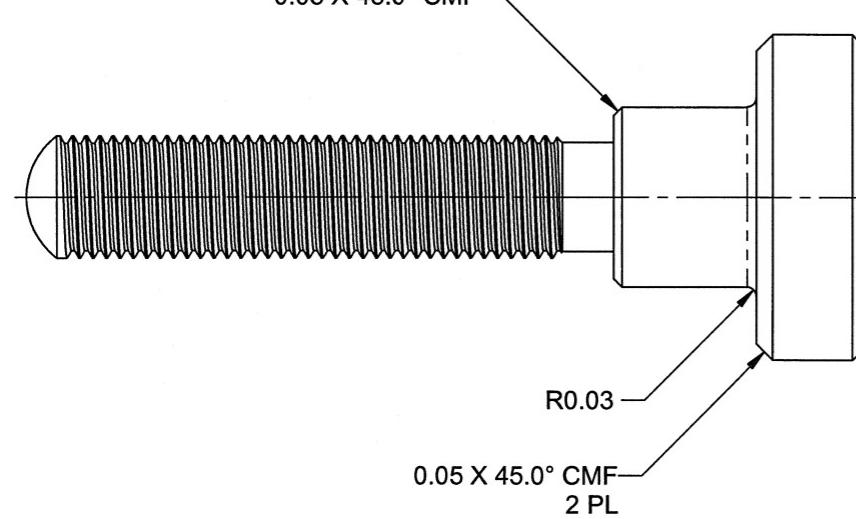
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### RBW6210G01631-8G-2 LOCKING SCREW

#### NOTES:

1) MATERIAL: 303/304/316 STAINLESS STEEL

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	DP	RBW6210G01631-8G	
APPROVED		REV. C SHEET 4 OF 13	
TITLE		M/R BLADE LOCKING PROTECTION TOOL	
DATE 2019-07-03		SCALE	NTS
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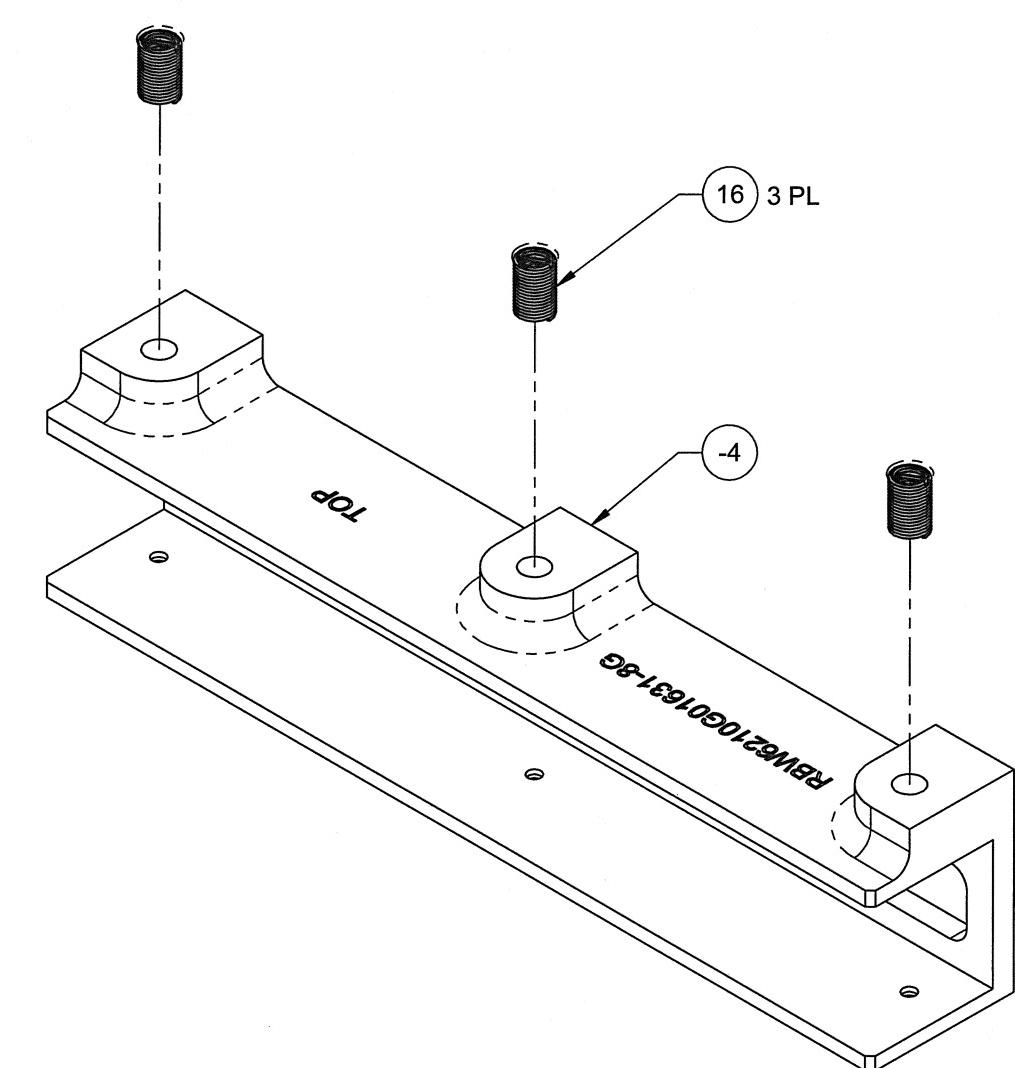
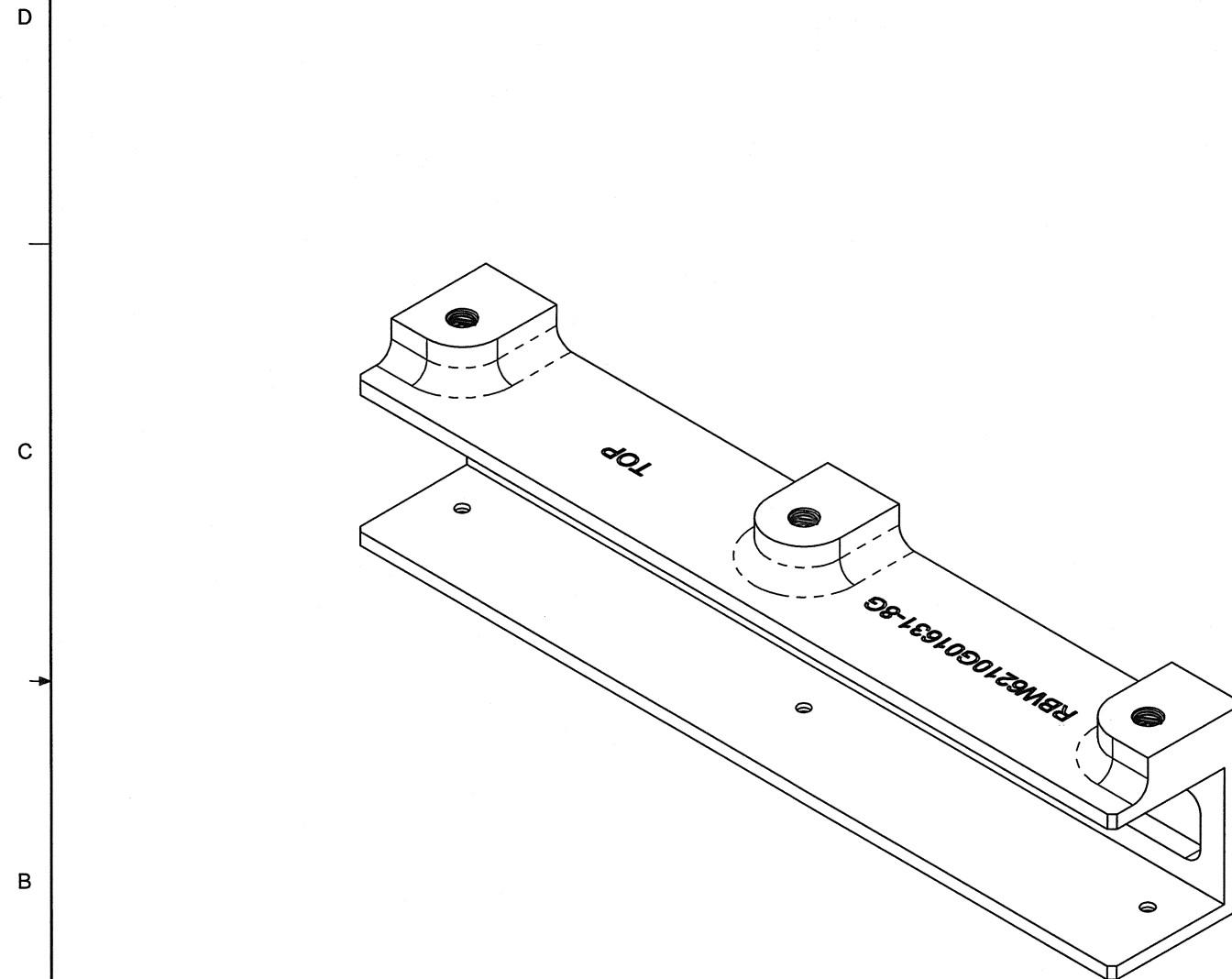
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ITEM #	QTY	PART #	PART TITLE
-4	1	RBW6210G01631-8G-4	SUPPORT
16	3	McMaster#91732A749 OR EQUIV.	SS HELICAL INSERT 3/8"-24 X 3/4" LG.



### RBW6210G01631-8G-3 SUPPORT ASSY

#### NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	REV. C
MFG. APPR.	DP	RBW6210G01631-8G	SHEET 5 OF 13
APPROVED		TITLE	M/R BLADE LOCKING PROTECTION TOOL
DATE 2019-07-03		SCALE	NTS
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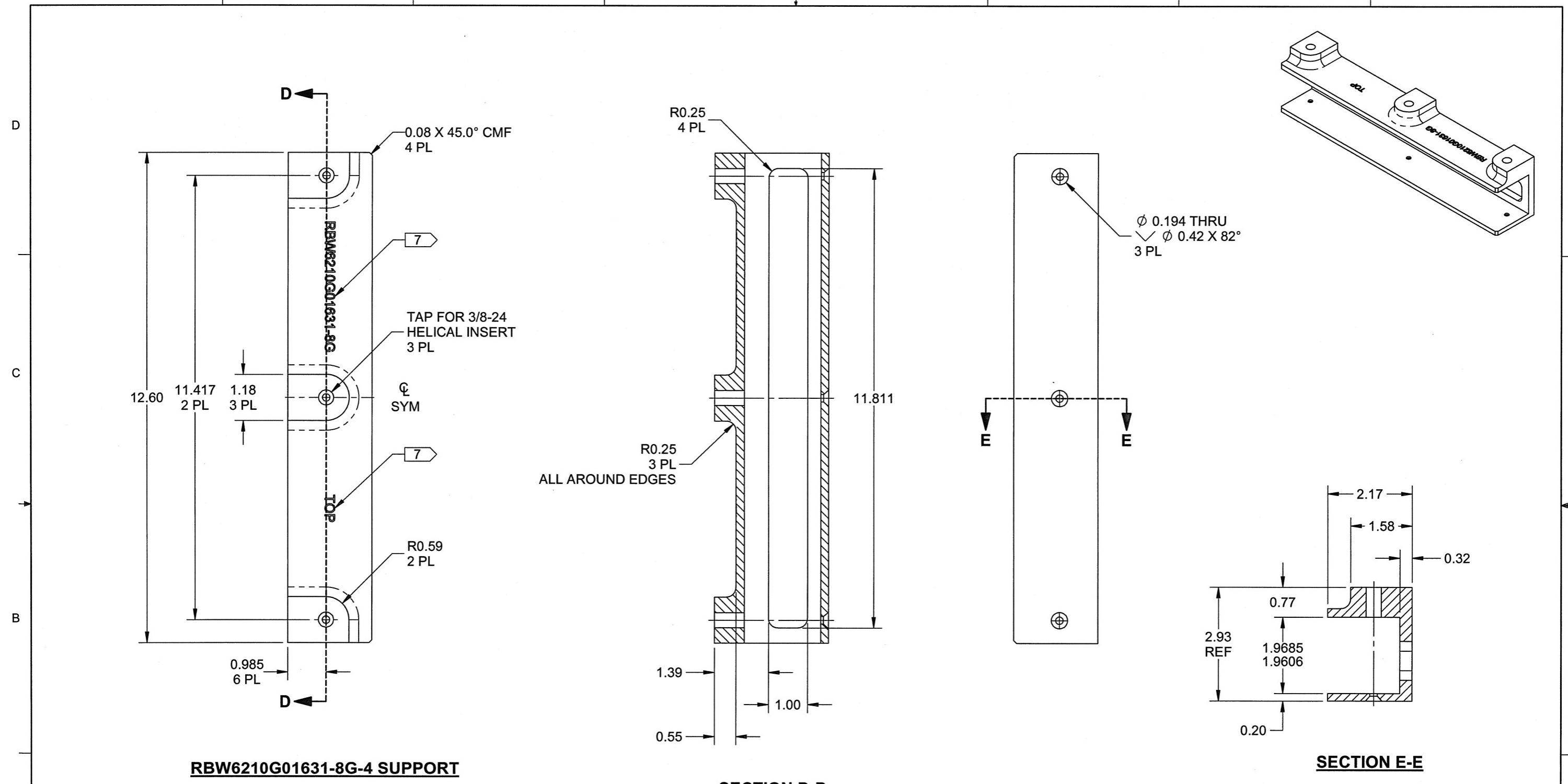
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**NOTES:**

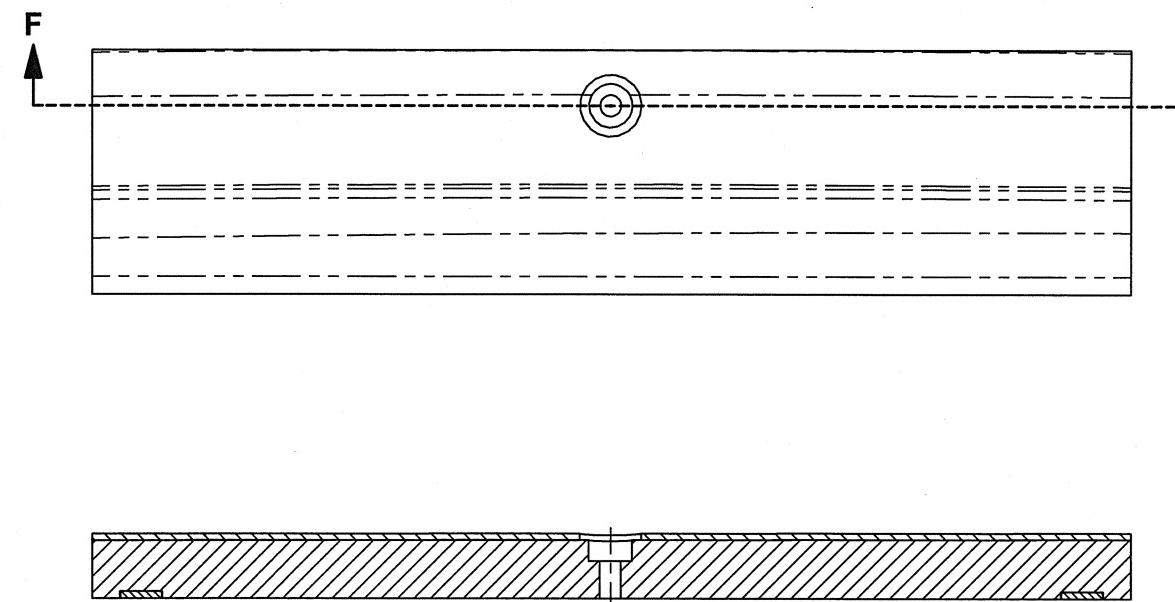
- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK, AS SHOWN

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. C	
MFG. APPR.	DP	TOOL PART # RBW6210G01631-8G SHEET 6 OF 13	
APPROVED	<i>[Signature]</i>	TITLE M/R BLADE LOCKING PROTECTION TOOL	
DATE 2019-07-03		SCALE NTS	
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ITEM #	QTY	PART NUMBER	PART TITLE
-6	1	RBW6210G01631-8G-6	UPPER PLATE
-7	1	RBW6210G01631-8G-7	UPPER PLATE PROTECTION
-8	2	RBW6210G01631-8G-8	REACTION

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**SECTION F-F****RBW6210G01631-8G-5 UPPER PLATE ASSY****NOTES:**

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

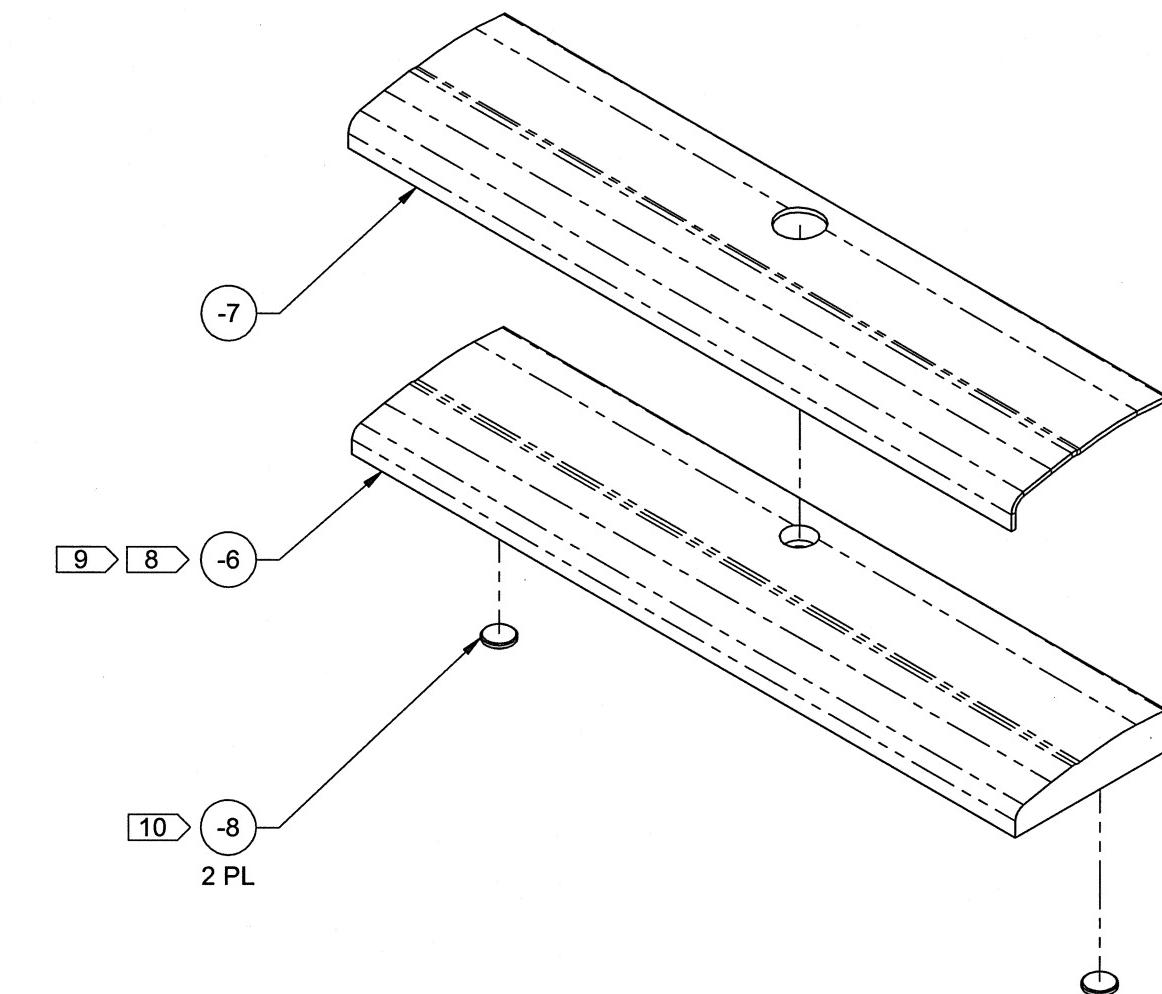
6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) ASSEMBLE ITEM -7 ADHESIVE SIDE ON ITEM -6 AS SHOWN, AND CUT EXCESS IF NECESSARY

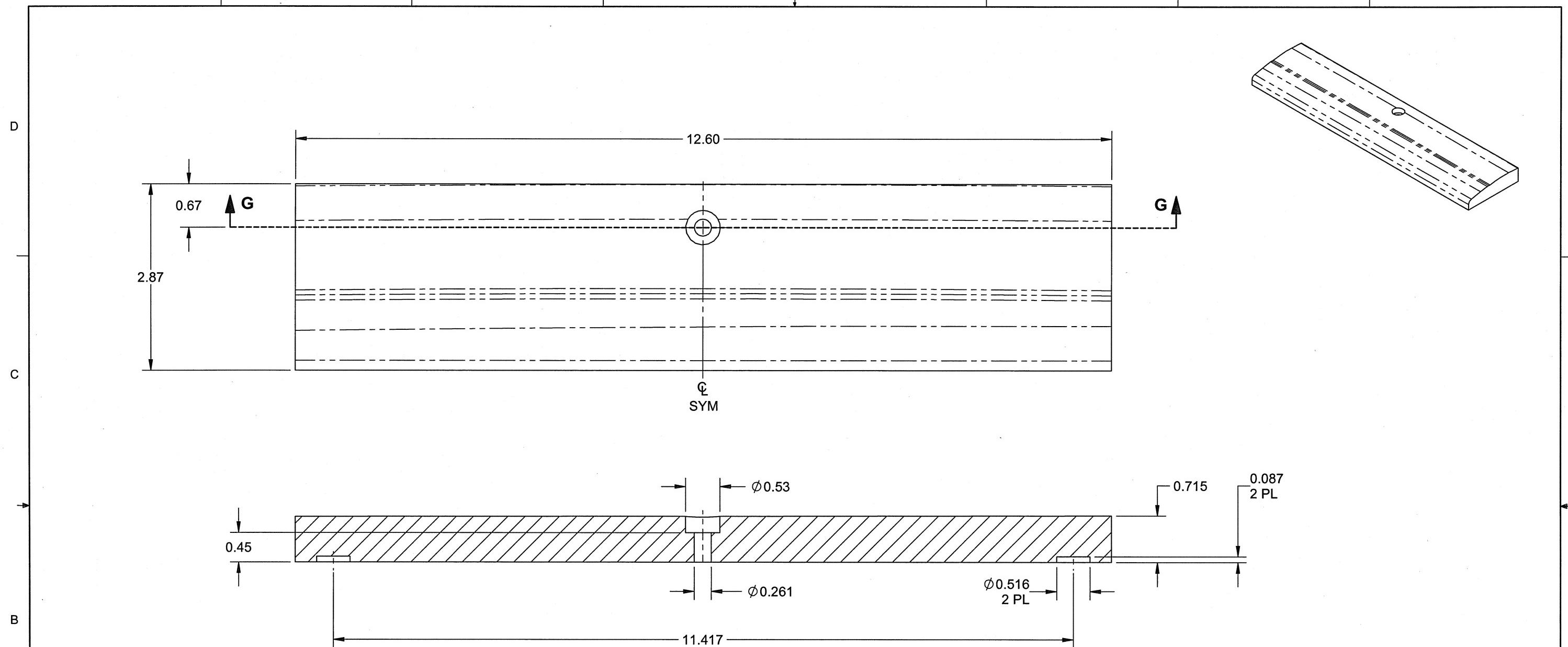
9) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEM -7 AND ITEM -6 IF NECESSARY, AND REMOVE EXCESS

10) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEM -8 AND ITEM -6, AND REMOVE EXCESS



DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	
MFG. APPR.	DP	REV. C	RBW6210G01631-8G
APPROVED	<i>[Signature]</i>	SHEET 7 OF 13	TITLE
DATE 2019-07-03		M/R BLADE LOCKING PROTECTION TOOL	
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SECTION G-G

RBW6210G01631-8G-6 UPPER PLATE

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A NOTES:

- 1) MATERIAL: UHMW
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RBW6210G01631-8G-6 REV. C.STEP

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	DP	REV. C	
APPROVED	WJP	RBW6210G01631-8G	
DATE 2019-07-03		SHEET 8 OF 13	
TITLE		SCALE	NTS
M/R BLADE LOCKING PROTECTION TOOL		NTS	
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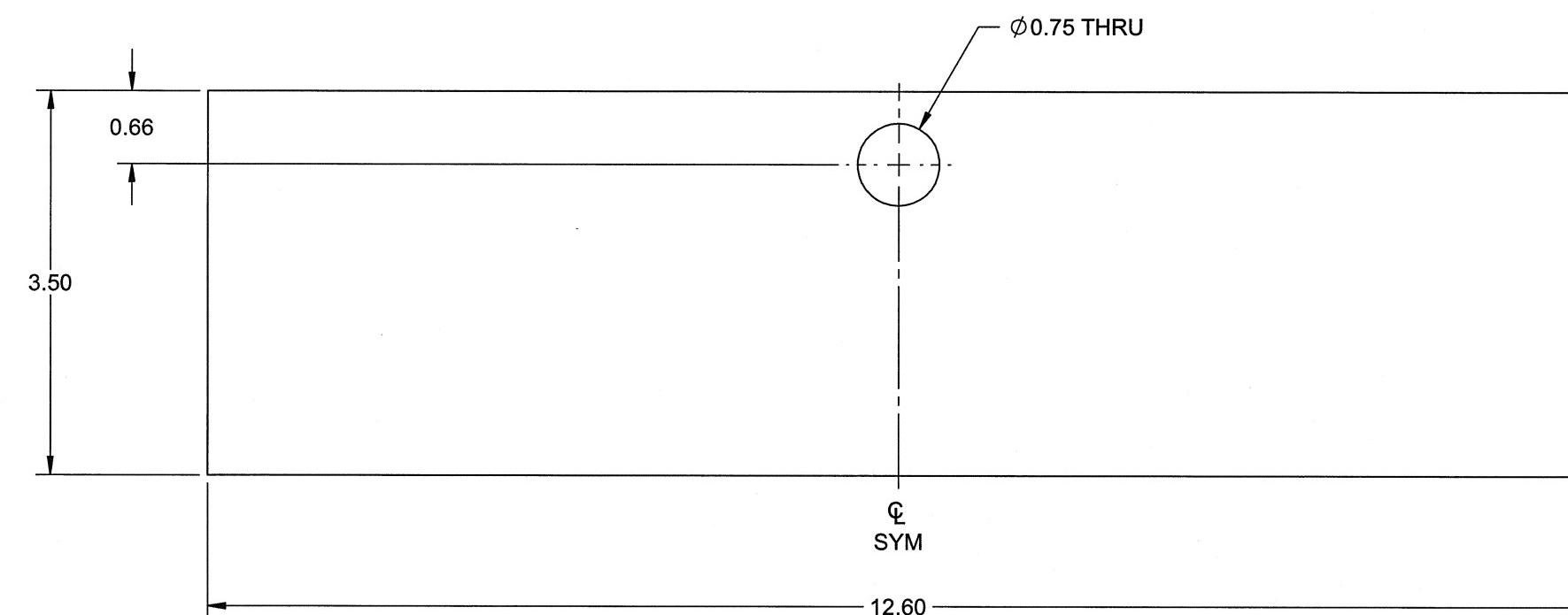
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**FLAT PATTERN**

**RBW6210G01631-8G-7 UPPER PLATE PROTECTION**

**NOTES:**

1) MATERIAL: McMaster#1374N33 OR EQUIV. (NEOPRENE RUBBER SHEET 50A DUROMETER X 1/16" THK.)

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES:  $X.X = +/- 0.1"$  /  $+/- 1^\circ$

$X.XX = +/- 0.01"$  /  $+/- 0.5^\circ$

$X.XXX = +/- 0.005"$  /  $+/- 0.1^\circ$

$X.XXXX = +/- 0.0005"$  /  $+/- 0.05^\circ$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $+/- 0.005"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	DP	REV. C	
APPROVED	<i>[Signature]</i>	RBW6210G01631-8G	
DATE 2019-07-03		SHEET 9 OF 13	
TITLE		SCALE	NTS
M/R BLADE LOCKING PROTECTION TOOL			
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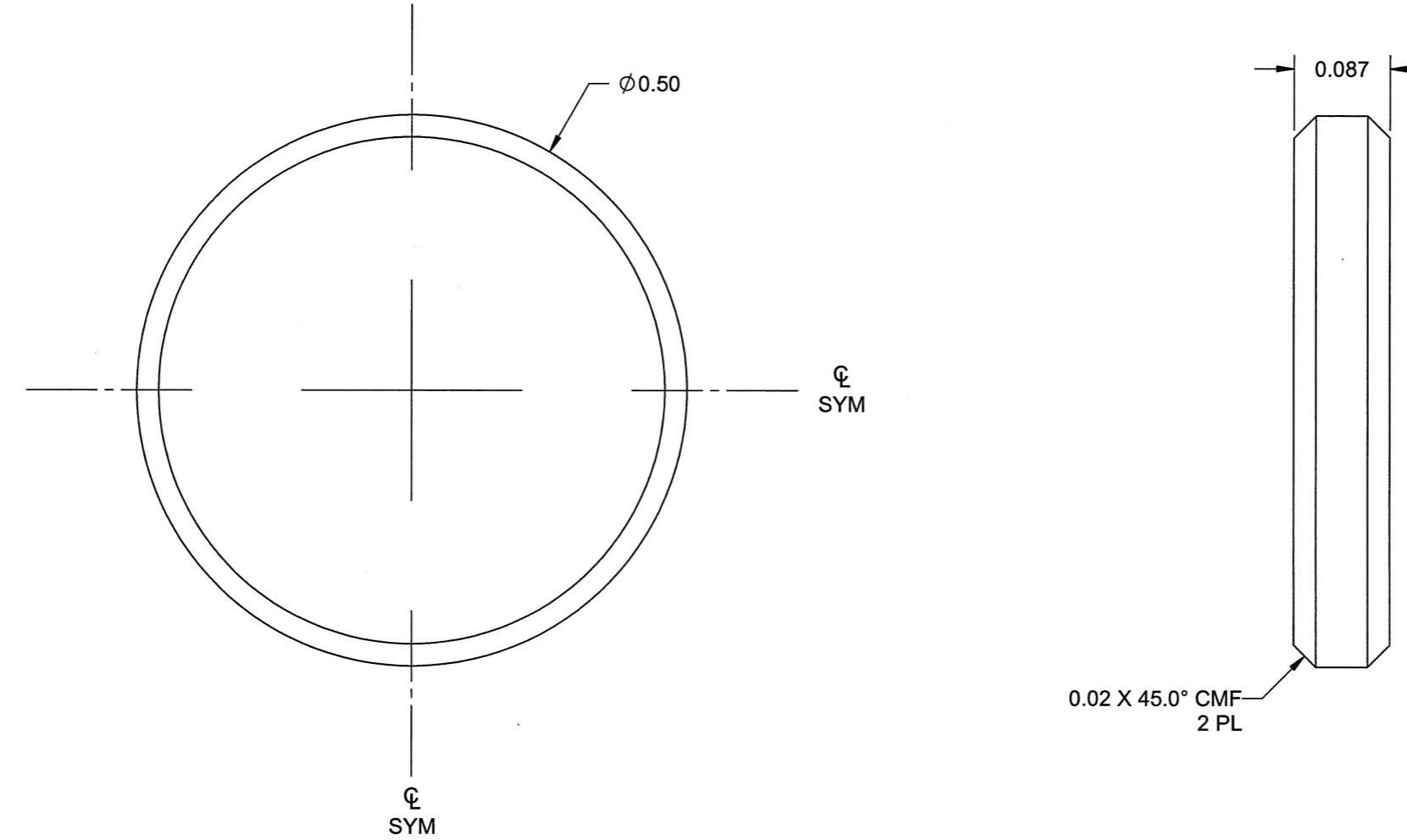
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### RBW6210G01631-8G-8 REACTION

#### NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	
MFG. APPR.	DP	REV. C <b>RBW6210G01631-8G</b>	
APPROVED	VIP	SHEET 10 OF 13	
TITLE		SCALE	
M/R BLADE LOCKING PROTECTION TOOL		NTS	
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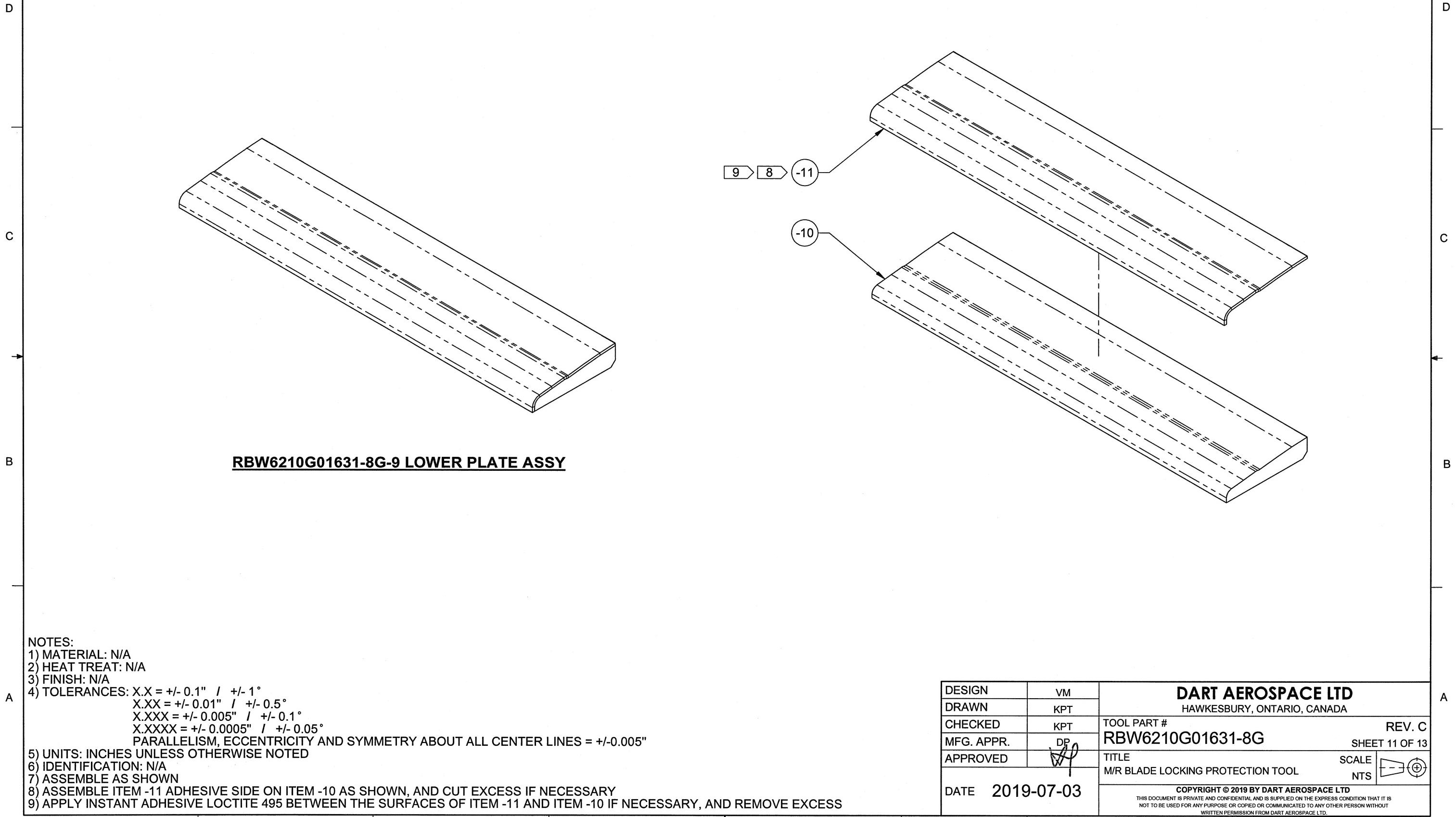
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ITEM #	QTY	Part #	PART TITLE
-10	1	RBW6210G01631-8G-10	LOWER PLATE
-11	1	RBW6210G01631-8G-11	LOWER PLATE PROTECTION



DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	REV. C TOOL PART # <b>RBW6210G01631-8G</b> SHEET 11 OF 13	
MFG. APPR.	DP		
APPROVED		TITLE M/R BLADE LOCKING PROTECTION TOOL SCALE NTS	
DATE 2019-07-03			

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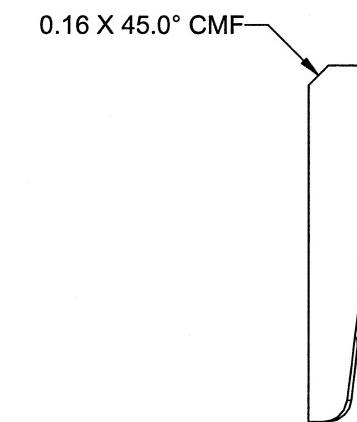
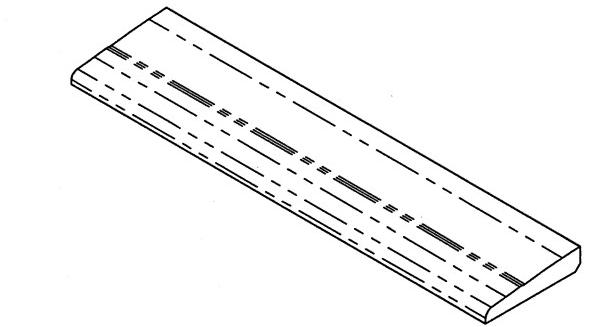
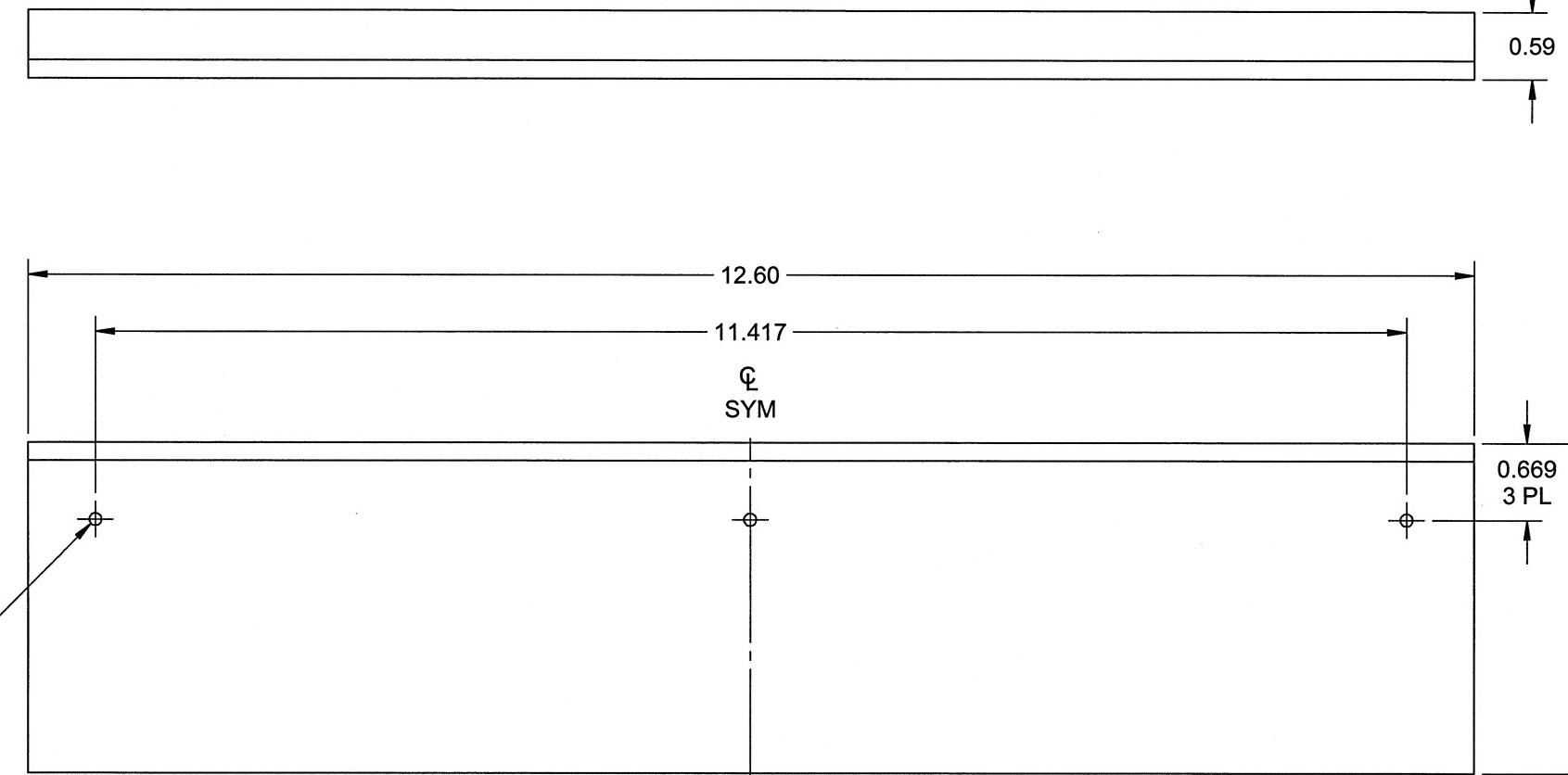
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### RBW6210G01631-8G-10 LOWER PLATE

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#### NOTES:

- 1) MATERIAL: UHMW
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
 X.XX = +/- 0.01" / +/- 0.5°  
 X.XXX = +/- 0.005" / +/- 0.1°  
 X.XXXX = +/- 0.0005" / +/- 0.05°  
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RBW6210G01631-8G-10 REV. C.STEP

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	KPT	TOOL PART #	
MFG. APPR.	DP	RBW6210G01631-8G	
APPROVED	VJ	REV. C SHEET 12 OF 13	
TITLE		SCALE	
M/R BLADE LOCKING PROTECTION TOOL		NTS	
DATE 2019-07-03		COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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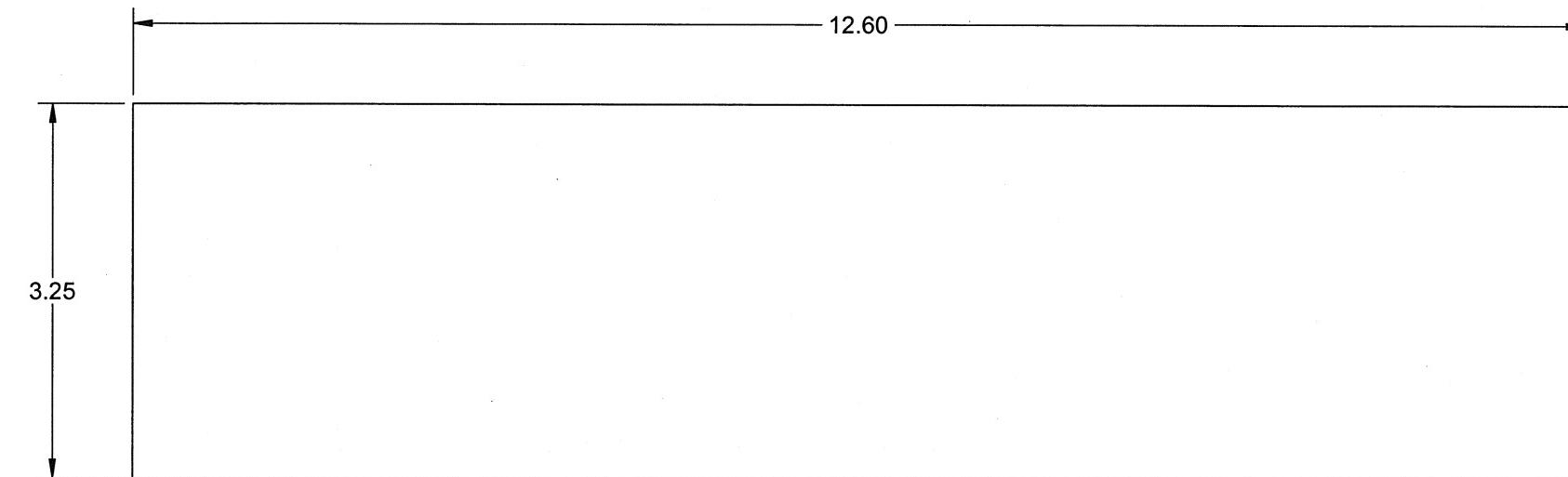
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### FLAT PATTERN

### RBW6210G01631-8G-11 LOWER PLATE PROTECTION

#### NOTES:

- 1) MATERIAL: McMaster#1374N33 EQUIV. (NEOPRENE RUBBER SHEET 50A DUROMETER X 1/16" THK.)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	DP	REV. C	
APPROVED	XJP	RBW6210G01631-8G	
DATE 2019-07-03		SHEET 13 OF 13	
TITLE		SCALE	NTS
M/R BLADE LOCKING PROTECTION TOOL			
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